Work Order ID 71211

Thursday, June 23, 2011 3:21:08 PM

Item ID: D3492-13 **Accept** **Setup** **Start**

Revision ID: **Stop**

Item Name: Plug

Start Date: 6/24/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 7/7/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Run **Start** **Stop**

Approvals: **Process Plan:** MF **Date:** 11-06-23 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D3492	D

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Hardinge CNC LATHE SMALL	0.00				25	Ø		
Hardinge	**Memo**	0.00							
Hardinge CNC Lathe Small	1-Turn as per Folio FA715 & Dwg D3492 Dwg Rev: N/A Folio Rev: N/A								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				25	Ø		
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00				25	Ø		
QC	**Memo**	0.00							
Quality Control									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 71211

Thursday, June 23, 2011 3:21:09 PM

Item ID: D3492-13 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Plug

Start Date: 6/24/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 7/7/2011 **Req'd Qty:** 20.00 **Customer:**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00				25	Ø		
Small Fab	Memo	0.00							
Small Fab	1-Deburr	11/7/6							
140	QC5-Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00				25	Ø	BK 11-7-6.	
HandFinish	Memo	0.00							
Hand Finishing									

Dart Aerospace Ltd

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H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 71211

Thursday, June 23, 2011 3:21:09 PM

Item ID: D3492-13 **Accept** **Setup Start**

Revision ID: **Stop**

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Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat						20	ø	MJ	11/07/08
Powder Coating	**Memo**	0.00							
M 117745	(Flat End Only) START TIME: 8:45 OVEN TEMPERATURE: 320°F FINISH TIME: 9:15								
170	QC3- Inspect Part Finish	0.00							
QC						20	ø	MJ	11/07/08
Quality Control	**Memo**	0.00							
180	Identify as per dwg & Stock Location: FP-B	0.00							
Packaging						20	ø	MJ	11/07/08
Packaging	**Memo**	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 71211

Thursday, June 23, 2011 3:21:09 PM

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Revision ID: **Stop**

Item Name: Plug

Start Date: 6/24/2011 **Start Qty:** 20.00 **Cust Item ID:**

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run** **Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							11/7/11
QC Quality Control	**Memo**	0.00							

MF
11-07-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 23, 2011 3:21:04 PM

Work Order ID: 71211

Parent Item: D3492-13

Parent Item Name: Plug

Start Date: 6/24/2011 **Required Date:** 7/7/2011

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 6061-T6 Round Bar .750"		Purchased	No			100	f	61.2030	0.05	1.052682		11/7/6	

Location	Loc Qty	Loc Code
MAT013	61.203	
112442	0.796	
116406	0.617	
117481	35.79	
118106	24	

1.42 Pt

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	71211
Description: Plug	Part Number:	D3492-13
Inspection Dwg: D3492 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.750	+/-0.010	Ø.746	✓			
Ø0.510	+/-0.010	Ø.510	✓			
0.045	+0.000/-0.002	.044	✓			
0.060	+/-0.005	.061	✓			
0.060	+/-0.005	.060	✓			
0.500	+/-0.010	.500	✓			
0.090	+0.000/-0.002	.090	✓			

Measured by:		Audited by:	B.A	Preliminary Approval:	
Date:	11/7/6	Date:	11/07/06	Date:	

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3492-053	KJ/DD	
B	09.05.04	Ø0.750 was Ø0.625	KJ/DD	
C	08.09.04	Tolerance revised for Ø0.750	KJ/DD	
D	10.11.05	Dimension Ø0.510 was Ø0.520	KJ	
E	11.06.21	Dwg Rev updated	KJ	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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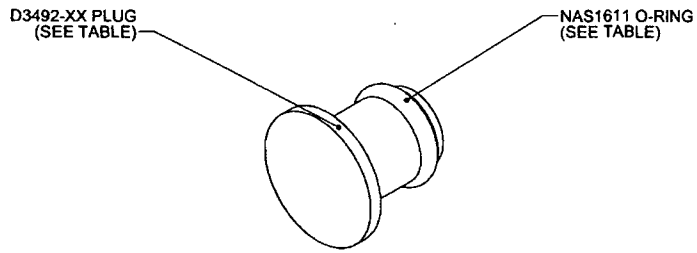
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

71211

RELEASED
2011 -05- 30

REV.	DESCRIPTION	BY	DATE
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3492	REV. D SHEET 1 OF 2
MFG. APPR.			
APPROVED		TITLE PLUG	SCALE 2:1
DE APPR.			
DATE	11.05.24		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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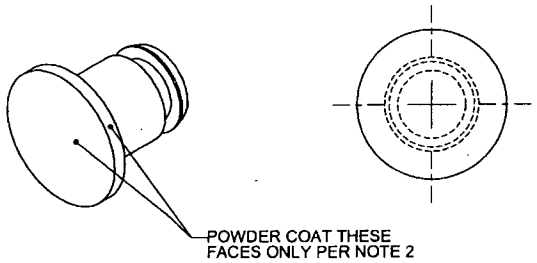
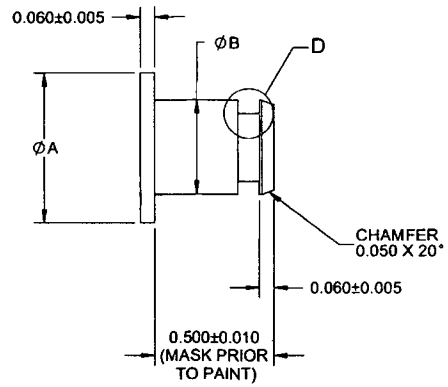
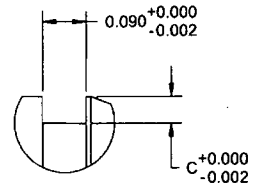
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





D3492-XX PLUG



DETAIL D

#71211

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750

D

D

RELEASED
2011 -05- 3

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR
QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100)
(REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D3492 — REV. D — SHEET 2 OF 2
MFG. APPR.		
APPROVED		TITLE: PLUG — SCALE: 4:1
DE APPR.		
DATE	11.05.24	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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